



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

000418
D350-607-431
Job Sheet 170986

Part No: D350-607-431

Job Qty: 1 ea

Part Name: AS350/AS355 Quick Release Basket Strut Retrofit



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 2/9/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV E IPP REV:A 13.12.30 NEW ISSUE DD VERF: RQ IPP REV:B 14.02.03 D350-607-4 REV:C DD VERF:JLM IPP REV:C 14.06.10 AS PER ECN14-572 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/9/18	0.00	0.00	Start Up Stores/Pkg-2		Wk
120	Packaging	1 pcs		2/9/18	0.00	0.00	Packaging1-3		
130	QC	1 pcs		2/9/18	0.00	0.00	QC4		Smb
135	DC	1 pcs		2/9/18	0.00	0.00	DC		
140	Packaging	1 pcs		2/9/18	0.00	0.00	Packaging3-1		Smb
150	QC21-FG	1 Ea		2/9/18	0.00	0.00	QC21		

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-14A	Bolt	12 Ea (12 ea)	90-Start up Operation	
AN4-42A	Bolt	4 Ea (4 ea)	90-Start up Operation	
AN6-13A	Bolt	2 Ea (2 ea)	90-Start up Operation	
D3501-1	Bushing	8 Ea (8 ea)	90-Start up Operation	
D3910-5	Crosstube Lug	1 Ea (1 ea)	90-Start up Operation	
D3910-7	Crosstube Lug	1 Ea (1 ea)	90-Start up Operation	
D3984	Rubber Extrusion, Crosstube (\$ Per Foot)	2 Ea (2 ea)	90-Start up Operation	
D4775-041	Strut Assembly	2 Ea (2 ea)	90-Start up Operation	
D4776-3	Skidtube Clevis	2 Ea (2 ea)	90-Start up Operation	
D4917-300	Placard, Max Load	1 Ea (1 ea)	90-Start up Operation	
D4917-310	Placard, Max Load	1 Ea (1 ea)	90-Start up Operation	
D4917-315	Placard, Max Load	1 Ea (1 ea)	90-Start up Operation	
D4917-320	Placard, Max Load	1 Ea (1 ea)	90-Start up Operation	
D4917-332	Placard, Max Load	1 Ea (1 ea)	90-Start up Operation	
MS21042L4	Nut	16 Ea (16 ea)	90-Start up Operation	
MS21042L6	Nut	2 Ea (2 ea)	90-Start up Operation	
NAS1149F0432P	Washer	24 Ea (24 ea)	90-Start up Operation	
NAS1149F0663P	Washer	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-14A	12	788	0
	AN4-42A	4	97	0
	AN6-13A	2	47	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ De _____	DISPOSITION Rework ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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DART
 AEROSPACE
S041009

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AS350/AS355 Quick Release Basket Strut Retrofit

PART NO: D350-607-431
Original Serial #: S041009
Revision:
Operation:
Change No: CHG003

Start up Operation
 02/09/18
 Job No: 170986

Root Cause	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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OTHER : _____

D3501-1	8	248	0
D3910-5	1	30	0
D3910-7	1	24	0
D3984	2	50	0
D4775-041	2	22	0
D4776-3	2	16	0
D4917-300	1	2	0
D4917-310	1	5	0
D4917-315	1	1	0
D4917-320	1	3	0
D4917-332	1	1	0
MS21042L4	16	2,809	0
MS21042L6	2	514	0
NAS1149F0432P	24	2,032	0
NAS1149F0663P	4	108	0

Part Specifications

Specifications could not be found.

Plex 1/25/18 11:30 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					



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Master Unit 000418

Containers on Master Unit 000418				
Serial No	Part No	Customer Part No	Status	Quantity
S038388	AN4-14A		Allocated	12
S038383	AN4-42A		Allocated	4
S038381	AN6-13A		Allocated	2
S038380	D3501-1		Allocated	8
S038378	D3910-5		Allocated	1
S038371	D3910-7		Allocated	1
S038843	D3984-030	D3984-030	Allocated	8
S038366	D4917-300	D4917-300	Allocated	1
S038364	D4917-315		Allocated	1
S020814	D4917-320	D4917-320	Allocated	1
F156736	D4917-332		Allocated	1
S038362	MS21042L4	MS21042L4	Allocated	16
S038357	MS21042L6		Allocated	2
S038355	NAS1149F0432P		Allocated	24
S038354	NAS1149F0663P		Allocated	4

100 ——— D4775-041 5042601
 110 ——— D4776-3 5042309
 110 ——— D4917-310 5042202

7.0 CONVERSION & OPTIONAL KITS PARTS LIST

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT
1	1	1	1		D2530	HANDLE ASSEMBLY
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D3501-1	BUSHING
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG
1					D3914-041	LONG BASKET LID ASSEMBLY
		1			D3915-041	LONG BASKET LID ASSEMBLY (LIGHTWEIGHT)
6	6	6	6		D3917-3	WASHER
1	1	1	1		D3953-9	GAS SPRING WASHER
				4	D3984-030	RUBBER EXTRUSION, X-TUBE
	1				D4018-041	SHORT BASKET LID ASSEMBLY
			1		D4019-041	SHORT BASKET LID ASSEMBLY (LIGHTWEIGHT)
1					D4086-200	PLACARD, MAX LOAD
1					D4086-210	PLACARD, MAX LOAD
		1			D4086-215	PLACARD, MAX LOAD
	1	1			D4086-220	PLACARD, MAX LOAD
	1		1		D4086-232	PLACARD, MAX LOAD
			1		D4086-243	PLACARD, MAX LOAD
				2	D4775-041	STRUT ASSEMBLY
				2	D4776-3	SKIDTUBE CLEVIS
1				1	D4917-300	PLACARD, MAX LOAD
1				1	D4917-310	PLACARD, MAX LOAD
		1		1	D4917-315	PLACARD, MAX LOAD
	1	1		1	D4917-320	PLACARD, MAX LOAD
	1		1	1	D4917-332	PLACARD, MAX LOAD
2	2				AN3-16A	BOLT
		2	2		AN3-20A	BOLT
3	3	3	3		AN4-12	BOLT (DRILLED)
				12	AN4-14A	BOLT
					AN4-22A	BOLT
				4	AN4-42A	BOLT
2	2				AN5-17A	BOLT
		2	2		AN5-21A	BOLT
				2	AN6-13A	BOLT
3	3	3	3		AN310-4	CASTELLATED NUT
2	2	2	2		AN310C4	CASTELLATED NUT
					AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
2	2	2	2		MS21042L5	NUT (OR MS21042-5)
				16	MS21042L4	NUT (OR MS21042-4)
				2	MS21042L6	NUT (OR MS21042-6)
3	3	3	3		MS24665-151	COTTER PIN
2	2	2	2		MS24665-300	COTTER PIN
2	2	2	2		NAS1149C0432R	WASHER
6	6	6	6	24	NAS1149F0432P	WASHER
2	2	2	2		NAS1149F0563P	WASHER
				4	NAS1149F0663P	WASHER

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Revision: E
 Date: 16.11.25